

Date: Tuesday, 08/07/2008 1:01:06 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM GUIDE
 Job Number : 40368
 Estimate Number : 12657
 P.O. Number :
 This Issue : 08/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 05024
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-05-29 new issue DD verified by:EC

Part Number : D35893
 Drawing Number : D3589 REV B PRELIM
 Project Number : N/A
 Drawing Revision : B PRELIM
 Material :
 Due Date : 15/07/2008 Qty: 2 Um: Each

08.06.26
 POSITIVE
 RECALL
 ④

Additional Product

PRELIMINARY ISSUE

Job Number:



Sq. #: Machine Or Operation: Description:

1.0 M304RQ730 1.000" 3/4" 304 SS Roundbar



Comment: Qty.: 0.0569 f(s)/Unit Total: 0.1138 f(s)

φ.1.00" 3/4" 304 SS Roundbar

batch: M107904 x2

B17002 x2 J.F. 08/07/14

MNF 08/07/10

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA754 & DWG D3589

FOLIO REV: /

DWG REV: /

2-DEBURR AS REQUIRED

J.F. 08/07/14

MNF 08/07/10

④

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MNF 08/07/10

④

4.0 QC8 SECOND CHECK



ENGINEERING
APPROVAL



Comment: SECOND CHECK

08.07.21

RF 08/7/14

④

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PD 08-07-14

④

USED as D3589-041

B/N: BA0366

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 1:01:06 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM GUIDE

Job Number: 40368

Part Number: D35893

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/17

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08-07-21

POSITIVE RECALL
EFFECTIVE 08-07-21 AUTH [Signature]
RELEASED 09.02.17 DATE [Signature]

POSITIVE RECALL
EFFECTIVE 08-07-21 AUTH U
RELEASED [Signature] DATE 08.09.21

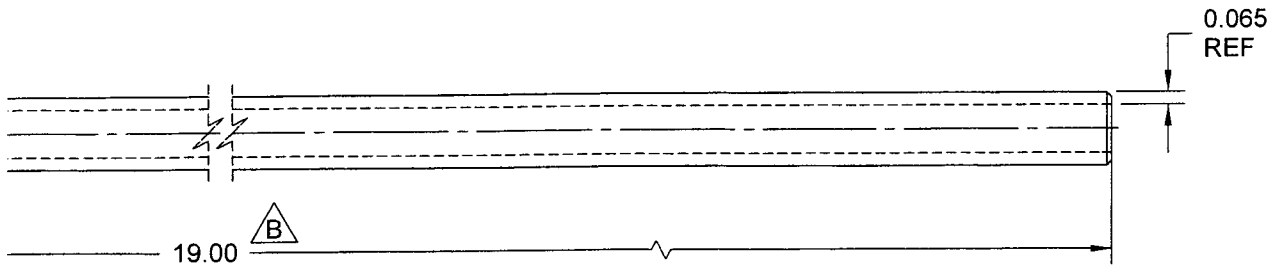
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

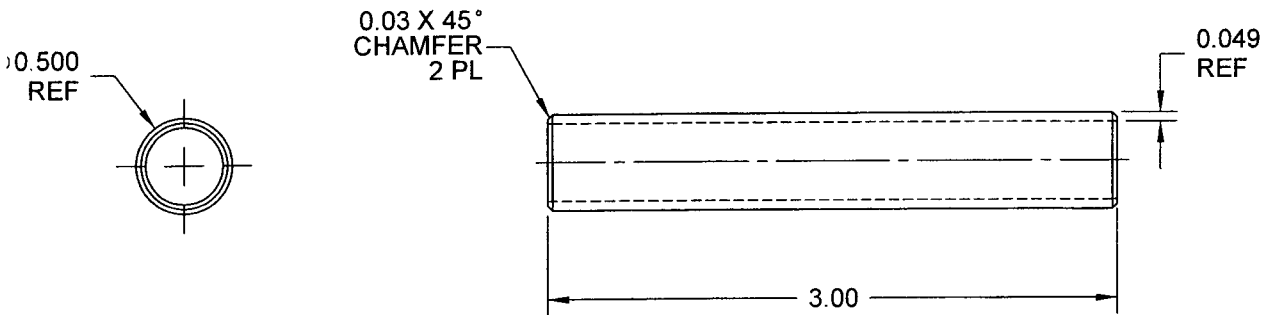
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RM



D3589-5 LATCH GUIDE

PRELIMINARY ISSUE
08.06.25

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

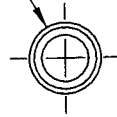
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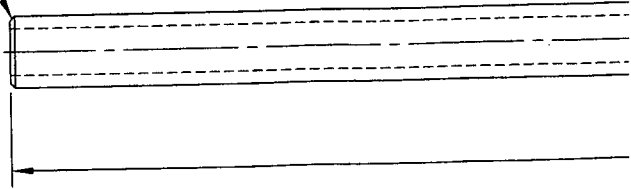
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D

Ø0.375
REF

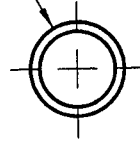


0.03 X 45°
CHAMFER
2 PL

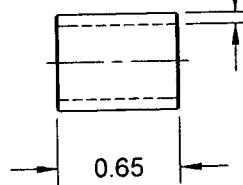
**D359**

C

Ø0.500
REF



0.058
REF



B

D3589-3 ARM GUIDE**D3589-1/-3/-5 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
 D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.0
 D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.0
 D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.0
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
 - D3589-3 = 0.01 lbs
 - D3589-5 = 0.06 lbs

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
User:Tuesday, 08/07/2008 1:01:06 PM
Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : ARM GUIDE

Job Number : 40368

Estimate Number : 12657

P.O. Number :

Part Number : D35893

This Issue : 08/07/2008

S.O. No. :

Drawing Number : D3589 REV B PRELIM

Prsht Rev. : NC

Project Number : N/A

First Issue : 11

Type : MACHINED PARTS

Drawing Revision : B PRELIM

Previous Run : 05024

Material :

Due Date : 15/07/2008

Qty: 2 Um: Each

Written By :

Checked & Approved By :

Comment :

Est Rev:A 08-05-29 new issue DD verified by:EC

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304RQ250

3/4" 304 SS Roundbar

*This Batch only**maurman 2/0: 2007603*

Comment: Qty.: 0.0569 f(s)/Unit Total: 0.1138 f(s)

*φ.1 cc 3/4" 304 SS Roundbar**batch: m107904 x2**(B17002) x2**J-F 08/07/14**MAW 08/07/10*

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA754 & DWG D3589

FOLIO REV: */*DWG REV: */*

2-DEBURR AS REQUIRED

*J-F 08/07/14**MAW 08/07/10**(4)*

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

*J-F 08/07/14**(4)*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MAW 08/07/10

4.0

QC8

SECOND CHECK



ENGINEERING APPROVAL



Comment: SECOND CHECK

*08-07-21**20 08/7/14**(4)*

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PD 08-07-14 (4)

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY
K6A 1K7

ON CAN

SHIPPED TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY
K6A 1K7

ON CAN

SHIP VIA		F.O.B.		SALESPERSON		YOUR ORDER NO.	
EPIC		BOUCHERVILLE		G. Dulude		2007603	
	Ordered	Description			Number Pieces	Quantity Shipped	Back Ordered
		Fax all papers to Linda Lacelle 613-632-4443					
		Mill tests required with all shipment					
					rev:07/02		
01	24/FT	ALUMINIUM SMLS TUBE					
		ATS 5.000 .125 E6061					
		HT#.....: 101521181			1	24/FT ✓	
		Total...			1	24/FT	
		Cust. part#: M6061T6T5.000W.125					CY 05/03/07
02	40/FT	STAINLESS ROUND BAR					
		SMOOTH TURNED A276, A484, A/SA182, A/SA479, A262					
		SBR 1.000 ST 304L					
		HT#.....: V2675			4	51/FT 4 IN ✓	
		Total...			4	51/FT 4 IN	
		Cust. part#: M304R1.000					CY 05/03/07

No. of Bdls/Pieces 1/ 1

Total Weight.....: 191

Customers.: _____



VENUS WIRE INDUSTRIES LIMITED

VENUS

REGD. OFFICE : 19, Raghuvanshi Mill Compound, S. B. Marg, Lower Parel, Mumbai-400 013. (INDIA)
Tel.: 91-22-24978840 • Fax : 91-22-24978846 • E-MAIL : sales@venuswires.com • Website : www.venuswires.com

ISO: 9002

REGISTERED FIRM

INSPECTION / MILL / QUALITY CERTIFICATE

No. BB/VW/2003-2004/1184

PRODUCT INFORMATION	CUSTOMER : UNALLOY-IWRC		GRADE : AISI-304/304L										
	INVOICE NO. : VW/197/EXP/2003-2004		HEAT NO.: V 2675										
	PRODUCT FORM : STAINLESS STEEL ROUND BAR												
	DIMENSION : 1.00"		TOL.: ASTM A484										
	QUANTITY : 4962.60 LBS.												
	IDENTIFICATION : AV 366,367,568												
CONDITION : ANNEALED+Peeled+CENTRELESS GROUND+POLISHED													
CHEMICAL COMPOSITION	Elements	C%	Si%	Mn%	P%	S%	Cr%	Ni%	Cu%	Mo%	N%	Nb%	CO%
	RESULTS	0.028	0.430	1.600	0.039	0.021	18.74	8.510	0.470	0.340	0.047	-----	0.079
MECHANICAL TESTS	UTS		YS		R.A. %		ELONGATION %		HARDNESS		GRAIN SIZE		
	RESULTS 93 KSI		48 KSI		71.24		54.50		172 BHN		5		
OTHERS	HEAT TREATMENT : 1050°C-SOLUTION ANNEALED,01 HOUR WATER QUENCH.												
	REMARKS : MATERIAL IS FREE FROM MERCURY CONTAMINATION. MICRO & MACRO TEST WAS FOUND SATISFACTORY. NO WELDING PERFORMED. MELTING PROCESS UHP CONVERTER VOD,HOT ROLLED. I.G.C.TEST FOUND OK. MATERIAL CONFORMS TO ASTM A276-SEPT.10,2000;A479/A479M-MAR10 2000;A182/182M-99;A262-NOV.10,1998 PRACTICE E;A314-SEPT.10, 97;A484/A484M-JUNE.10,2000;A193/A193M-99A B8 CL1;A320/A320M-AUG.94 CLASS1 B8;ASME SA479/479M-OCT.10,96;SA182-01 SECTION II,SA193-01 SECTIONII B8 CLASS1,SA320/320M-95 CLASS 1B8; QQS 763F COND.A,AMS 5639 REV G/5647 REV G;MIL-S-862B, UNS#S30400/S30403. PURCHASE ORDER NO.: 13115-000 OP												
This report is a copy of original mill certificate and verifies that the product meets the requirements as originally ordered by Unalloy/IWRC. SEP 24 2003 DATE: _____ VERIFIED BY: <i>LB</i>													
We hereby certify that the material described herein have been manufactured and tested with satisfactory results in accordance with the customers requirements, needs and expectations.													
DATE : 06/08/2003													
AUTHORIZED SIGNATORY <i>[Signature]</i>													

DOC. No.TC/10.1 Rev.: 1

PLANT : ATKARGAON, TAKAI ADOSHI ROAD, KHALAPUR, KHOPOLI-410 203
PHONES : 02192-262334 / 263404 / 262610 • FAX : (02192) 265865

Q.C. Reviewed
DEC 29 2004

SPECIALTY STEELS

290 Chemin du Tremblay Boucherville QC CAN J4B 5P2 TEL (514) 875-5555 FAX (514) 875-5557

SHIPPING MARK: 1111 1111
NAME OF CARRIER: 1111
P.O.B.: 1111

Att:
Linda Lacelle

COMBINATION SHORT FORM OF STRAIGHT BILL OF LADING-EXPRESS SHIPPING CONTRACT ADOPTED BY THE BOARD OF TRANSPORT COMMISSION FOR CANADA
SUBJECT TO THE JURISDICTION OF THE CANADIAN TRANSPORT COMMISSION

It is mutually agreed, as to each carrier of all or any of said goods over all or any portion of said route to destination, and as to each party at any time interested in all or any of said goods, that every service to be performed hereunder shall be subjected to all the terms and conditions (which are hereby incorporated by reference and have the same force and effect as if the same were fully and specifically set forth herein).

1. approved by the board of transport commission for Canada by General Order No. T-5, dated February 1, 1965 set forth in the Canadian freight Classification and also available at all railway agency stations and freight offices upon request, when said goods are carried by rail carrier; or
2. of the bill of lading set forth in or prescribed by the relevant tariffs, classification, statutes and regulations motor carrier's services when said goods are carried by a motor carrier; or
3. of the bill of lading form prescribed by the regulations adopted by the order-in-council #985-79 dated April 4, 1979
4. of the Shipping Contract approved by the Board of Transport Commission for Canada by General Order No. T-43 dated September 18, 1967 and set forth in Express Traffic Association; Tariff 100 in effect on the date hereof, when said goods are carried by an express carrier subject to the jurisdiction of the said Board; and which are agreed to by the shipper and accepted for himself and his assigns.

Consigned to:
DART AEROSPACE LTD
1270 ABERDEEN STREET

TELEPHONE 613 632 3336

HAWKESBURY


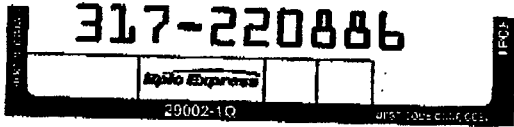
ON CAN K6A 1K7

Customer Order 2007656

Order Notes

Fax all papers to Linda Lacelle 613-632-4443
Mill tests required with all shipment

rev:07/02

Description of shipments and special marks	Weight	Pcs	If charges are to be prepaid write or stamp here:						
01-ST. ST. SMLS TUBE STB .500 .035 304L 03/03/2005 160 FT W2 HT#:2A031 Cust. part#: M304TR0.500W.035 Rev:	27.8	8	Collect						
02-STAINLESS STEEL TUBE A554 FINI MOULIN 304 STO .750 .750 .065 304APC 03/03/2005 340 FT FK HT#:7340687 Cust. part#: M304TS0.750W.065 Rev:	205.7	17	Received \$ To be applied in prepayment of the charges on the property described hereon						
03-ALUMINIUM SMLS TUBE T6 DRAWN B-210, WWT-700/6 ATS .375 .035 D6061 03/03/2005 108 FT RM HT#:39322 Cust. part#: M6061T6T0.375W.035 Rev:	4.8	9	Agent or Cashier Per FOR CARRIER'S USE						
04-ALUMINIUM SMLS TUBE T6 DRAWN B-210, WWT-700/6 ATS .375 .058 D6061 03/03/2005 168 FT RM HT#:175-39954 Cust. part#: M6061T6T0.375W.058 Rev:	11.4	14	Advance and or beyond \$ Misc. \$						
05-ALUMINIUM SMLS TUBE T6 DRAWN B-210, WWT-700/6 ATS .500 .058 D6061 03/03/2005 108 FT RM HT#:175-39326 Cust. part#: M6061T6T0.500W.058 Rev:	10.3	9	Suppl. Piece \$ Suppl. Value \$ TOTAL \$						
 			SHIPPER SHOW AMOUNT OF C.O.D.						
<table border="1"> <tr> <td>C</td> <td>Amount \$</td> </tr> <tr> <td>O</td> <td>Fee \$</td> </tr> <tr> <td>D</td> <td>Total \$</td> </tr> </table>			C	Amount \$	O	Fee \$	D	Total \$	Valuation
C	Amount \$								
O	Fee \$								
D	Total \$								
Eds/Pieces 2 + 0 = 2	Number of Extra Large pieces	Total weight 260 LB	Order number 1018612						
Dimensions Where required by the tariff shipper must complete the following	Total cubic feet	Dimensional weight	Customer						
Shipper V. C. Hubert (32)		Transport: EPR CARRIERS LONG Haul (20 Dics)							

Purchase Order

PO Number 2007603
Date 02-22-05
Account # QSI012-6

Vendor
Marron/Keystone Canada Ltd.
290 Chemin du Temblay
Boucherville QC
J4B 5X9

Sold To
Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury ON
Canada K6A 1K7

Ship To
S A M E

Attn Ghislaine
Vendor Tel (800) 361-8142
Vendor Fax (450) 641-4357

Purchaser
Telephone (613) 632-3336
Fax (613) 632-4443

Ship Via EPIC GST # RT101272607 PST # 61225207 OE # 0000WIP
FOB Point ORIGIN Comments: MATERIAL CERTIFICATION REQUIRED UPON DELIVERY
Freight Chgs Collect

Amt	Manuf	Mfg Part No	Our Part Number	Part Description	Delivery	Unit Price	Extended
40.00	Y	C205103107	M303R1.000	303 Round Bar 1.0"	03-02-05	5.8700 /f	234.80
NOTE: AISI 304/316 NOT ACCEPTABLE							
24.00	Y	C205102107	M6061T6T5.000W.125	6061-T6 Tube 5.00X.125W	02-24-05	16.0000 /f	384.00
6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS4080 OR AMS4082 OR QQ-A-200/8 OR QQ-A-225/8							

SIB M304 R1.000

Reals okay.

lock shift
222
D3264-3 R44
3264-5 P22
3357-3

Total Value of Purchase Order

\$618.80

Receiving Report

Date: 05/03/07
Supplier: Marmon - Keystone

Batch No: m17cc2
Dart P/O: 2007603

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☒ No ☐
Shipment Complete: Yes ☒ No ☐
Q.C. Inspection ☒

Discrepancies

Part No.	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
m303R1.000	Bau	40	51.4			

TSR No. _____

Production/Admin: 05.03.09
Date: 27603
Received/Costing: 4
Initial: 4
H:\ISO9000\Forms\Purchase\RECREPORT rev B

Initials of receiver (if shipment OK) CL
Accounting: _____
Date: _____
AP/MR: _____
Initial: _____

COPIED WIP
POSTED
POSTING: B3-15
APPROVAL: 05.03.28

ORIGINAL INVOICE / FACTURE ORIGINALE

15: NET 30 DAYS
2% PER MONTH ON
OVERDUE ACCOUNTS.

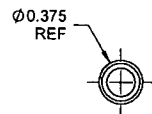
TERMES: NET 30 JOURS
PLUS 2% PAR MOIS
SUR COMPTE PASSÉ DÙ.

FOR CONDITIONS OF SALE REFER TO BACK OF INVOICE.
POUR LES CONDITIONS DE VENTE, VOUS TROUVEREZ LES
RENSEIGNEMENTS À L'ENDOS DE LA FACTURE ORIGINALE.

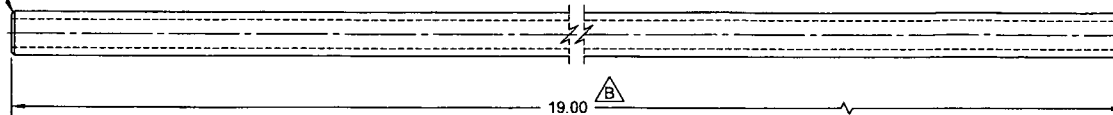
PAYMENT OF THIS INVOICE IS DUE BY
LE RÈGLEMENT DE CETTE FACTURE EST EXIGIBLE AU PLUS TARD LE

04/04/2005

G.S.T. /HST T.P.S.	51.63
PROVINCIAL TAX TAXE PROVINCIALE	.00
	789.25

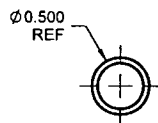


0.03 X 45°
CHAMFER
2 PL

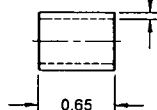


0.065
REF

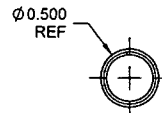
D3589-1 ARM



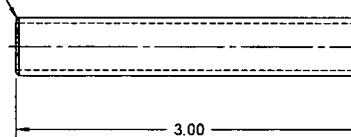
0.058
REF



D3589-3 ARM GUIDE



0.03 X 45°
CHAMFER
2 PL



0.049
REF

D3589-5 LATCH GUIDE

D3589-1/-3/-5 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
 D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
 D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
 D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
 - D3589-3 = 0.01 lbs
 - D3589-5 = 0.06 lbs

40368

RELEASED
09/02/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	